

Work Order ID 147750

June 10, 2016 3:09:45 PM

U/R

147750

Ball Only

Page 1

Item ID: D412-698-023

Revision ID: URF 16-531

Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 6/10/2016 Start Qty: 2.00

Required Date: 6/20/2016 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: *3A*

Date: *6/10/16*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E U/R								
100	Document Control	<i>DAS 6</i> 0.00		<i>JUN 15 2016</i>					<i>MLJ JUN 15 2016</i>
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-698-023		CHG002						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

2 **DAS**
27
9-89

2x **DA**
26
9-89 **DAS**
28
9-89 *JUN 14 2016*

2 **DAS**
27
9-89 *JUN 21 2016*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Work Order ID 147750

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147750

Page 2

Item ID: D412-698-023

Accept

N900040100Setup Start ***NS1***

Revision ID: URF 16-531

Item Name: Automatic Door Opener (fits LH or RH)

Stop ***NS2***Start Date: 6/10/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					2x	DAS 28 9-89	DAS 27 9-89	JUN 21 2016
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023 Location:FG022								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.03							
Quality Control									

SA 6/20/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY					
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong			
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions			
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance			
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect			
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing			
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved			
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing			
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish			
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread			
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence			
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____						
Misidentified ☐	☐ Past Due							

Picklist Print

June 10, 2016 3:09:50 PM

Page 1

Work Order ID: 147750

147750

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 6/10/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-11 *D3552-11* Door Prop		Manufactured	No			120	Each	19.0000	1	2			DAS 26 9-89

Location	Loc Qty	Loc Code
FG	4	
128491	2	
80345	2	
ST363	15	
142260	5	
145244	10	

JUN 14 2016

D3594-043 *D3594-043* Floor Doubler Assembly, LH	Manufactured	No				120	Each	11.0000	1	2			DAS 26 9-89
---	--------------	----	--	--	--	-----	------	---------	---	---	--	--	-------------------

Location	Loc Qty	Loc Code
Quarantine	1	
144903	1	
ST504	10	
130499	10	

DAS
26
9-89

D3594-044 *D3594-044* Floor Doubler Assembly, RH	Manufactured	No				120	Each	15.0000	1	2			DAS 26 9-89
---	--------------	----	--	--	--	-----	------	---------	---	---	--	--	-------------------

Location	Loc Qty	Loc Code
Quarantine	1	
144906	1	
ST504	14	
130500	14	

JUN 21 2016

Picklist Print

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Page 2

Work Order ID: 147750

147750

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 6/10/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3594-5 Manufactured No

120 Each

0.0000

1 2

D3594-5

Doubler

D3622-1

Manufactured No

120 Each

0.0000

2 4

D3622-1

Ball Stud

MS20426AD4-4

Purchased No

120 Each

4,415.000

2 4

MS20426AD4-4

Rivet

DAS
27
9-89

Location

Loc Qty

Loc Code

GA 1962
125445 1962
ST312 2453
m132536 2453

** 145406 x 2. SP DAS 28 9-89
** 144629 DAS 6 JUN 15 2016 DAS 28 9-89
** 26 DAS 28 9-89

MS21073L5 Purchased No

120 Each

16.0000

1 2

MS21073L5

Anchor Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

ST298 16
m132680 16

** 4x
** 2x
** 4

NAS1149D0516J Purchased No

120 Each

239.0000

2 4

NAS1149D0516J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST264 239
M129706 39
M134943 200

JUN 14 2016

June 10, 2016 3:09:50 PM

Shop Packet Print

Page 2

Under Review Notification

147731
OK 6/10/16

Raised By: M. BELLAVANCE

Product #: D412-698-023

Date: 16.02.25

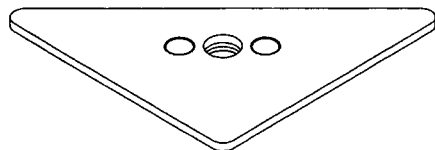
Product Name: AUTOMATIC DOOR OPENER KIT

Part Number (D-Part and 9-Digit)	Drawing/Document & Current Affected Revision	"Y" or "N" Required for Each Part							Reserved ECN Log Number	Instructions Relevant to Each Part
		HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise Customers	Stop Production	Re-Work Stock	IPP Under Review	Product Specifications Under Review		
D3594-043/-044/-3/-4	D3594 Rev. B	N	Y	N	Y	N	Y	N	16-531	See below.
D412-698-023	IIN-D412-698 Rev. E	N	Y	N	Y	N	Y	N	16-531	See below.

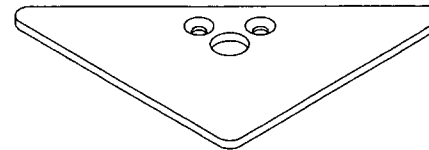
Description of Issue:

Current stock OK to ship to customers other than Bell Helicopter Mirabel.

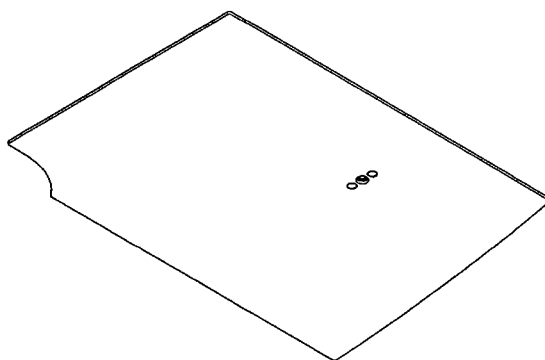
If shipping to Bell Helicopter Mirabel: must ship D412-698-023 with enlarged D3594-043/-044/-3/-4. Eng. To sign off deviations on W/Os.
Change: addition of material, 0.25", on the inboard and outboard edges as shown to facilitate installation with existing equipment.



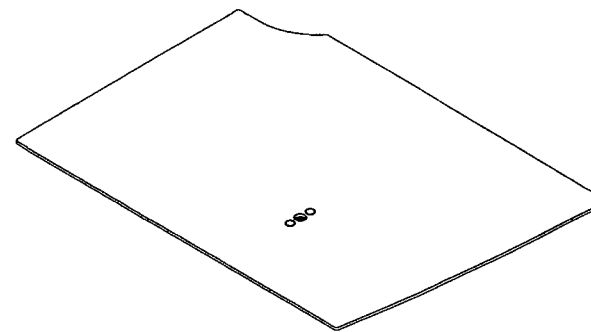
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY

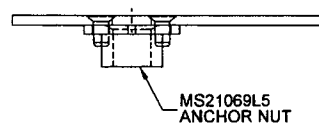
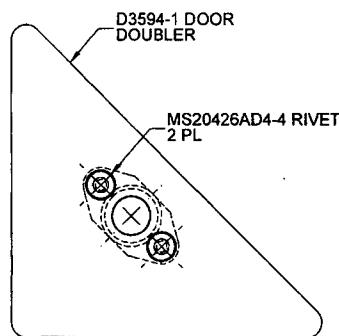


D3594-044 FLOOR DOUBLER ASSEMBLY

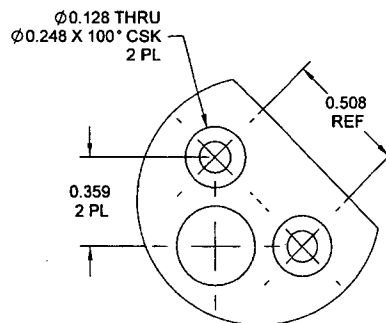
RELEASED
08.08.26

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3594 REV. B SHEET 1 OF 4 TITLE DOUBLER SCALE NTS DATE 08.05.14	
DRAWN	AJS		
CHECKED	[Signature]		
MFG. APPR.	[Signature]		
APPROVED	[Signature]		
DE APPR.	[Signature]	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

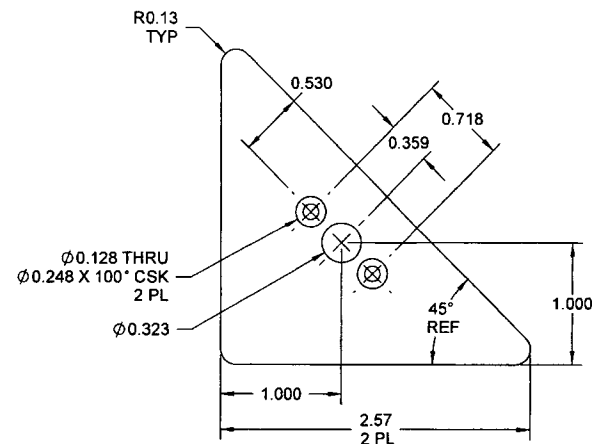
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



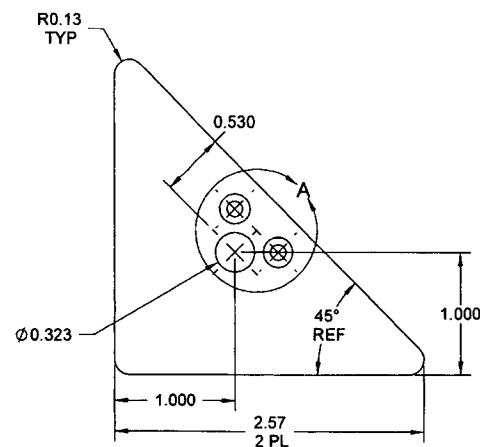
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER B

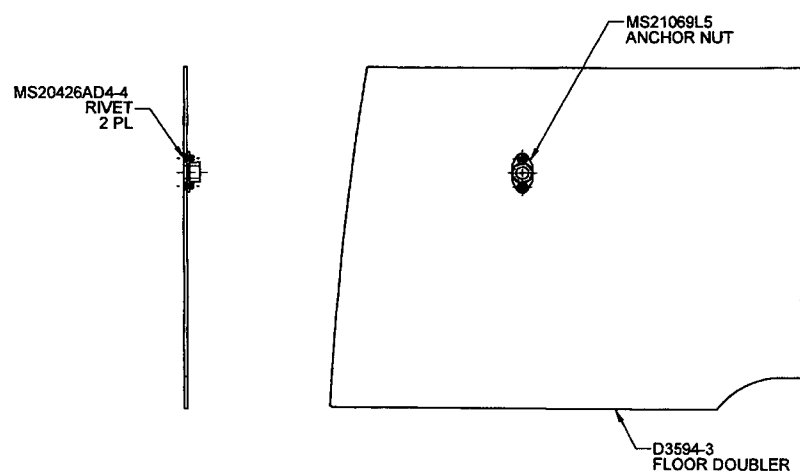
NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

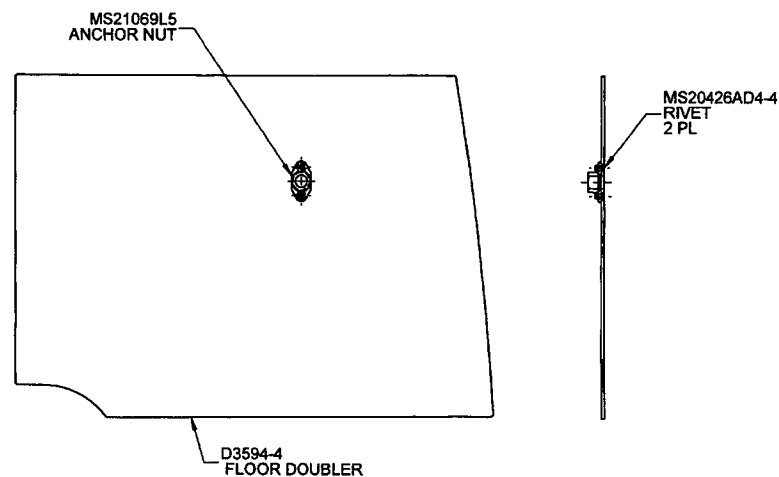
RELEASED
08-06-26-14

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.		TITLE DOUBLER	SHEET 2 OF 4
APPROVED			SCALE NTS
DE APPR.			
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



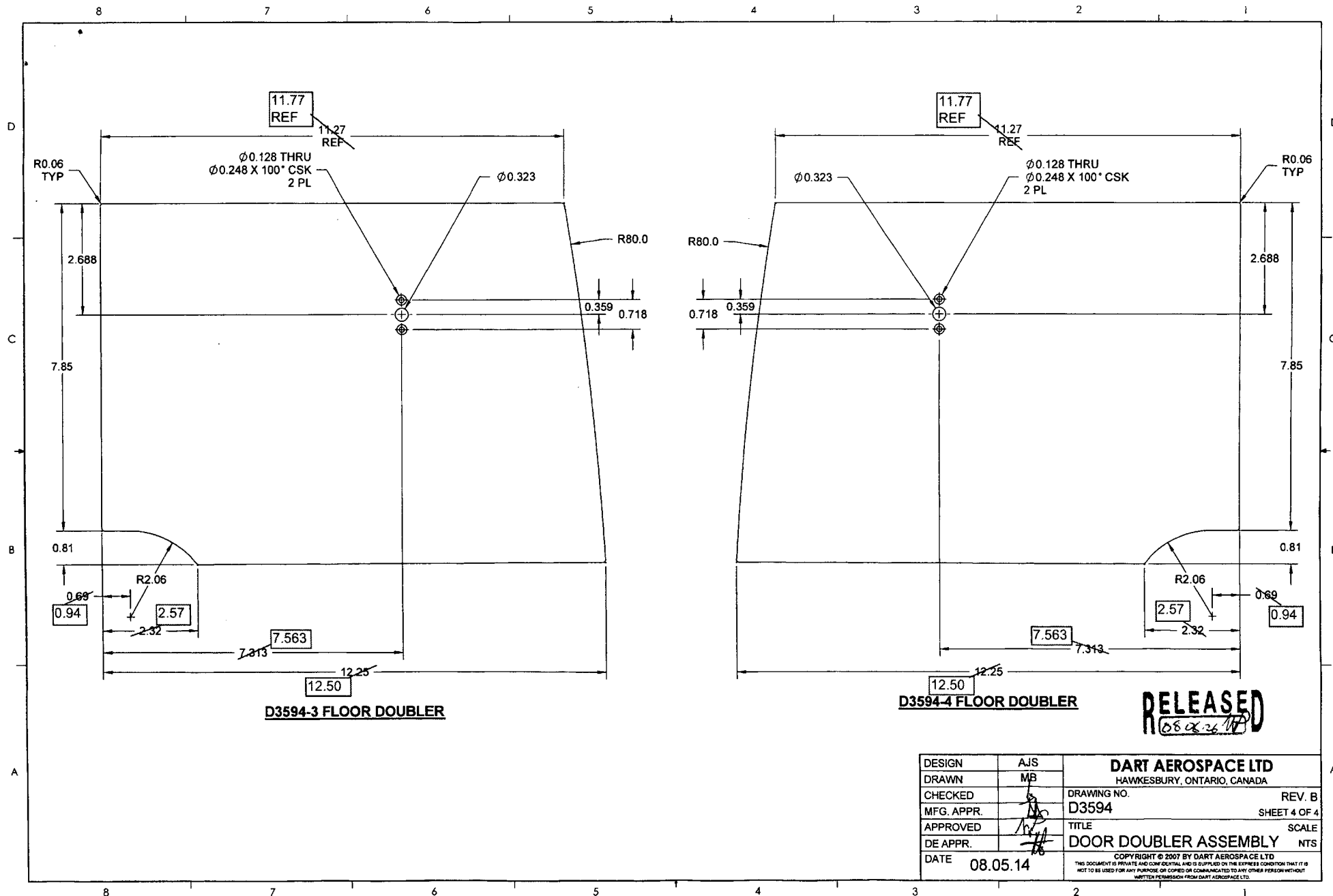
D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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RELEASED
08-06-2014



Work Order ID 147750

Wednesday, June 15, 2016 10:23:33 AM

147750

Page 1

Item ID: D412-698-023

Accept

N900040100Setup Start ***NS1***

Revision ID: URF 16-531

Stop ***NS2***

Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 6/10/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E U/R

100	Document Control	0.00
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100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-698-023 CHG002

MLJ JUN 15 2016

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Memo

0.00

Packaging

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC

Memo

0.01

Quality Control

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

DAS
21
8-88

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E

Date: 08.05.01